

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004566**Date Inspected:** 09-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** C.M. Chen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

Bay 2 OBG Assembly Area - QA Observations:

The Caltrans QA Inspector's have observed that there are 14 OBG assembly segments that are at various stages of fabrication relative to lifts 3, 4 and 5. 7 on the east span segments are being assembled at the south end of the bay and are identified as segments 3AE, 3BE, 4AE, 4BE, 5AE, 5BE, and 5CE. At the far north end of the bay there are 7 west span segments identified as 3AW, 3BW, 4AW, 4BW, 5AW, 5BW, and 5CW. based on periodic observations through out this shift the following applies to each segment observed.

South Fabrication Bay OBG Assemblies

OBG Assembly Segment 3AE- Caltrans QA observed ZPMC performing SMAW on vertical stiffeners to floor beam that were removed due to misalignment between connection plate. This was located at PP19.

OBG Assembly Segment 3BE- Caltrans QA observed ZPMC performing SMAW on vertical stiffeners to floor beam that were removed due to misalignment between connection plate. This was located at PP23.

OBG Assembly Segment 4AE- Caltrans QA observed this segment is idle on this date. There are no activities to

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report.

OBG Assembly Segment 4BE- Caltrans QA observed ZPMC personnel performing SMAW repair on longitudinal diaphragm 003-003 weld number 005.

OBG Assembly Segment 5AE- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 5BE- Caltrans QA observed ZPMC performing SMAW on vertical stiffeners to floor beam that were removed due to misalignment between connection plate. This was located at PP34.

OBG Assembly Segment 5CE – Caltrans QA observed this segment is idle on this date. There are no activities to report.

North Fabrication Bay OBG Assemblies

OBG Assembly Segment 5AW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 5BW- Caltrans QA observed ZPMC performing SMAW welding fillet weld on floor beam FL1-1 to FL2-1 flanges, vertical flange to top flange.

OBG Assembly Segment 5CW- Caltrans QA observed ZPMC performing SMAW lifting lugs at the pp35 location.

OBG Assembly Segment 4BW- Caltrans QA observed ZPMC performing SMAW welding temporary connection brackets to deck panels.

OBG Assembly Segment 4AW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 3BW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

OBG Assembly Segment 3AW- Caltrans QA observed this segment is idle on this date. There are no activities to report.

Summary of Conversations:

No relevant conversations spoken on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Dautermann, Peter (707) 552-7715, who represents the Office of Structural Materials for your project.

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Inspected By:	McClendon,Timothy	Quality Assurance Inspector
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Reviewed By:	Cuellar,Robert	QA Reviewer
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